

Date: Tuesday, 10/24/2006 11:03:41 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEBBING TIDY
 Job Number : 29139
 Estimate Number : 11381
 P.O. Number : *N/A* Part Number : D32153
 This Issue : 10/24/2006 S.O. No. : *N/A* Drawing Number : D3215 REV C
 Prsht Rev. : NC Project Number : *N/A*
 First Issue : *N/A* Type : SMALL / MED FAB Drawing Revision : C
 Previous Run : 28878 Material : *N/A*
 Due Date : 11/10/2006 Qty: 100 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 06 10 24
 Comment : Est. A04.04.06 New issue KJ/RF
 Est Rev:B Now on Waterjet 06-07-03 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0271 sf(s)/Unit Total : 2.7090 sf(s)

5052-H32 .040 Sheet

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S.040)

Identify for D3215-3A

Batch: *m101875*

m1 08 11 01

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3215

Dwg Rev: *C*

Prog Rev: *C*

m1 06/10/01

(100)

2-Deburr if necessary

m1 06-11-06 (99)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

m1 06/11/01

(100)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06/14/02

counted

(99)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 11:03:41 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 29139

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M5052H32S040

5052-H32 .040 Sheet



Comment: Qty.: 0.0084 sf(s)/Unit Total: 0.8400 sf(s)

5052-H32 .040 Sheet

Batch: M101875

MF. 06/11/06

99✓

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut blank: 2.130" x 0.530"

MF. 06-11-06

99✓

2-Deburr

MF. 06-11-06

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/11/08

99✓

8.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form D3215-3A as per Dwg D3215

SB 06/11/08

99✓

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DA 06/11/08 (99)

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004

A/R AL ROD BATCH: M18838

PE. 06.11.11

99✓

Identify as D3215-3

Grind flush

FF 06.11.13 (39) PE. 06.11.11 PE. 06.11.14 (59)

99✓

(59)

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DA 06/11/15 (95)

(PTO)

(95)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/11/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/15	10	4 parts was scrap when grinding weld took to much material off	CP 06.11.24 pw QSI/042	destroy	SB 06/11/15	MS 06/11/15	CP 06.11.24 pw QSI/042	2 06.11.15

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 11:03:41 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 29139

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/15 (95) ✓

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC 1/2 06/11/15 x 95 ✓

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

Q.M. 06/11/23 (95) ✓

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/11/23 (95) ✓

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST416 06/11/23 (95) ✓

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/24 (95) ✓

Job Completion



C Loc 11/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

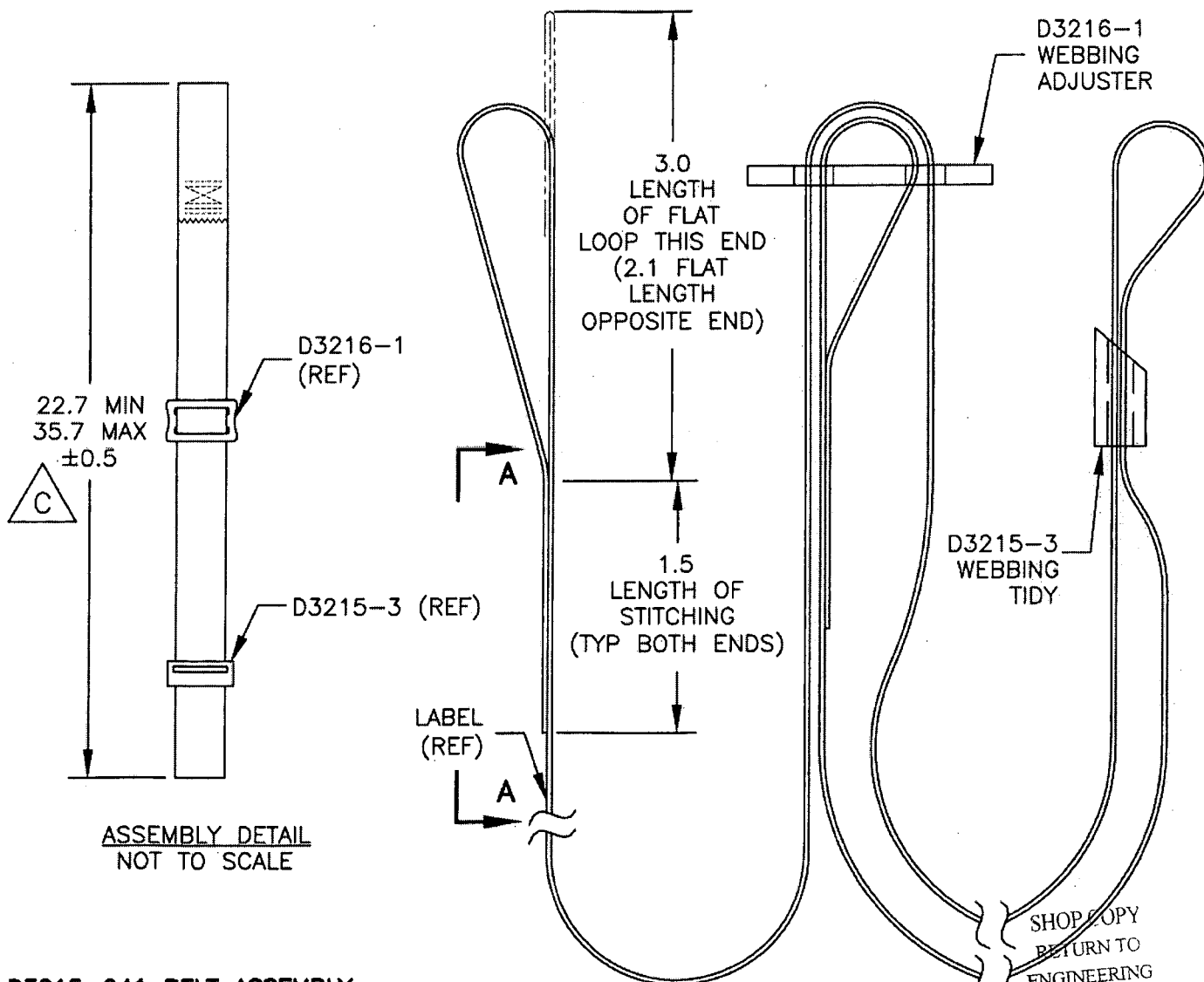
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>ap</i>	DRAWN BY	<i>ap</i>	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D3215	REV. C SHEET 1 OF 3
DATE	04.03.05	TITLE	BELT ASSEMBLY	SCALE	NTS
A	03.09.19	NEW ISSUE			
B	04.01.12	AS MANUFACTURED; ADD TOLERANCE			
C	04.03.05	REDUCE LENGTH; CLARIFY STITCHING			

RELEASED
04.03.08



D3215-041 BELT ASSEMBLY

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472
(2" WIDE x 0.060" THICK BLACK POLYESTER WEBBING
TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN)
THREAD = VT 295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD
LABEL = TYVEK

2) ALL DIMENSIONS ARE IN INCHES

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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NO. 29139

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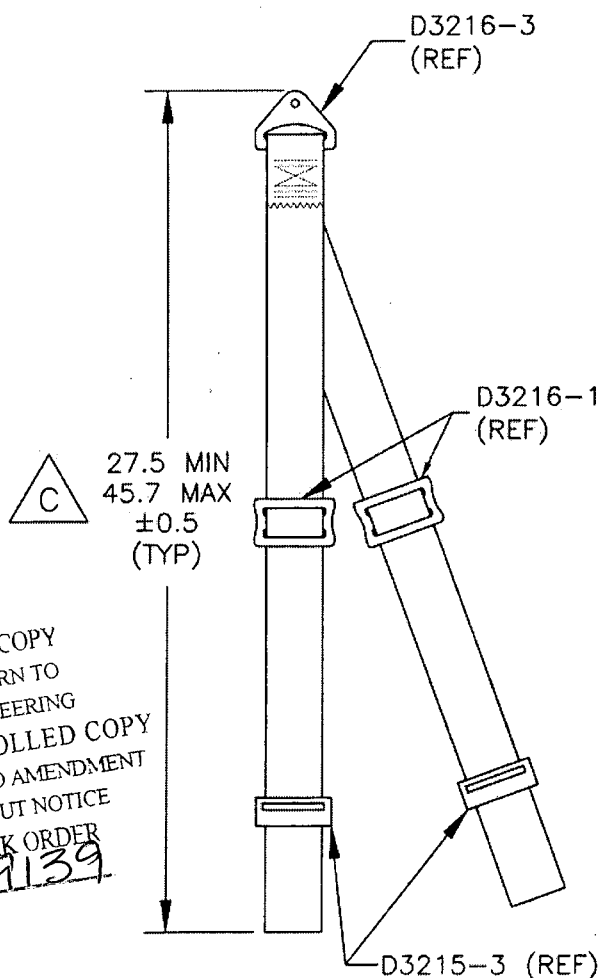
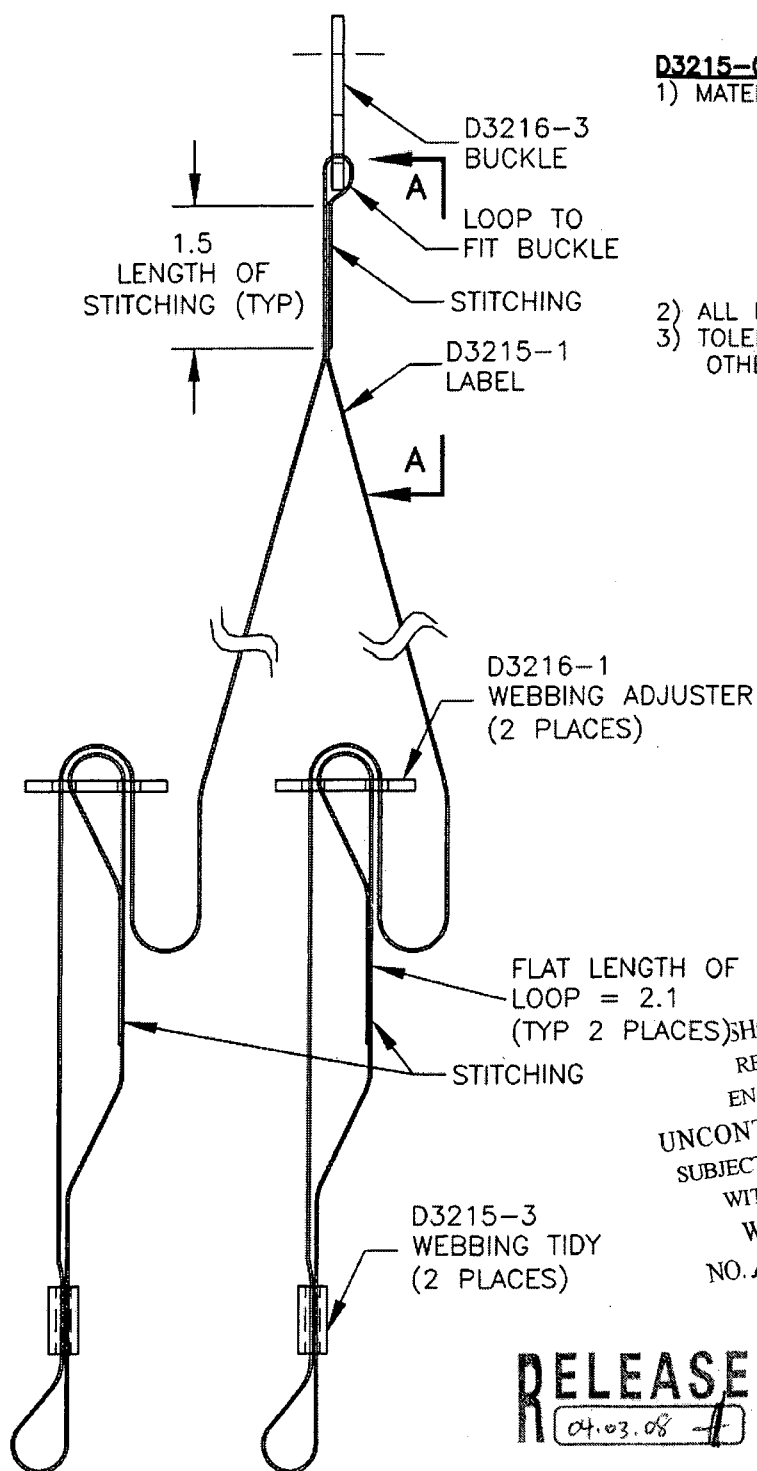
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3215	REV. C SHEET 2 OF 3
DATE 04.03.05		TITLE BELT ASSEMBLY	SCALE NTS

D3215-043 BELT ASSEMBLY

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472
(2" WIDE x 0.060" THICK
BLACK POLYESTER WEBBING,
CERTIFIED TO FAR 29.853A3,
TENSILE STRENGTH 5700 lb MIN)
THREAD = VT 295 TYPE II CLASS A SIZE 3,
BLACK NYLON THREAD
LABEL = TYVEK
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED.



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RELEASED
04.03.08

ASSEMBLY DETAIL
NOT TO SCALE

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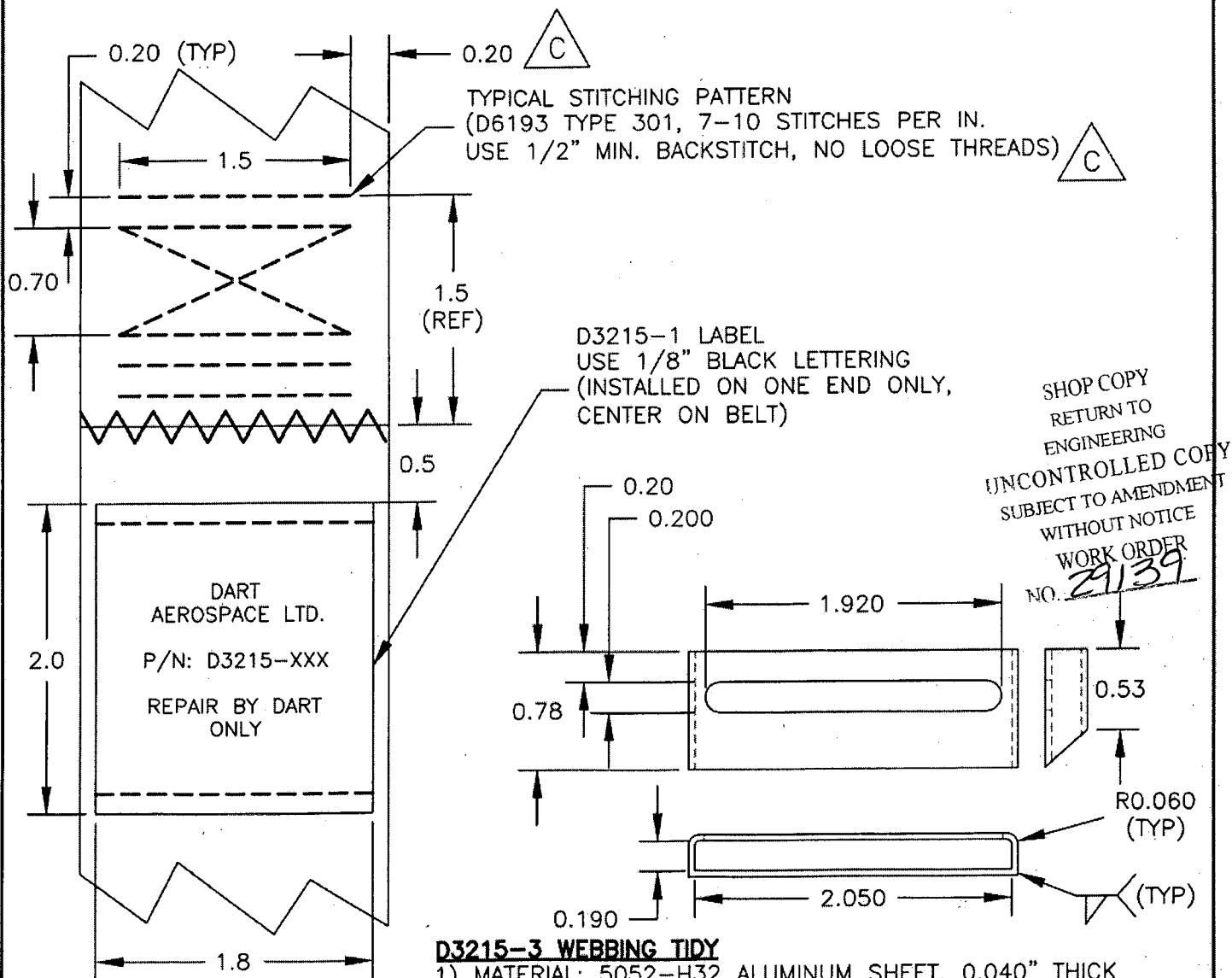
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DESIGN	APPROVED	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3215	REV. C SHEET 3 OF 3
DATE 04.03.05	TITLE HARNESS ASSEMBLY		SCALE 1:1

VIEW A-A

XXX = 041 FOR D3215-041
XXX = 043 FOR D3215-043



RELEASED
04.03.08

D3215-3 WEBBING TIDY

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040" THICK
(REF DART SPEC. M5052H32S.040)
- 2) WELD PER DART QSI 004
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED

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